

Work Order ID 131452

Thursday, April 09, 2015 11:23:58 AM

131452

Page 1

Item ID: D4470-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Rib Assembly, RH *2 CL 15/05/09*
 Start Date: 4/9/2015 Start Qty: *100* ***1*** Cust Item ID:
 Required Date: 4/29/2015 Req'd Qty: *100* ***1*** Customer:
 Reference:

Approvals: Process Plan: *MF* Date: *5-4-9* Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4470	REV C								
100		0.00							
100									
Bandsaw	Memo	0.00							<i>CL 14/04/28</i>
Jeaspa Bandsaw	CUT BLANK 17" LONG								
110		0.00							
110									
Purchasing	Memo	0.00							<i>CL MAR 04 2015</i>
Purchasing	ISSUE P/O: <i>28350</i> TO ARCHUR PRESISION(GLOBUS) C OF C IS REQUIRED								
120	<i>QC6</i> Inspect dimensions to drawing	0.00							
120	<i>Receiving</i>								
QC	Memo	0.00							<i>2x SP 15-05-29</i>
Quality Control									

125

QC6 inspection

(2)

048
38
9-89

JUN 01 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
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Work Order ID 131452

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131452

Page 3

Item ID: D4470-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Aft Rib Assembly, RH

Stop

NS2

Start Date: 4/9/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/29/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC14- Inspect Spray Paint

0.00

190

QC

Memo

0.00

Quality Control

2DAS
38
9-89

JUN 18 2015

191

0.00

191

Small Fab

Memo

0.00

Small Fab

install nutplates as per dwg

22DAS
36
9-89
15/06/22

192

QC5- Inspect part completeness to step on W/O

0.00

192

QC

Memo

0.00

Quality Control

2DAS
27
9-89

JUN 23 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Thursday, April 09, 2015 11:23:58 AM

131452

Page 4

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Aft Rib Assembly, RH

Stop *NS2*

Start Date: 4/9/2015 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 4/29/2015 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

200

Identify as per dwg & Stock Location: S-T236 0.00

0.00

200

Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

2116 JUN 23 2015

JUN 24 2015

ML5

415-0624

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Misidentified ☐	Past Due ☐	OTHER :																							

Picklist Print

Thursday, April 09, 2015 11:23:57 AM

Page 1

Work Order ID: 131452

131452

Parent Item: D4470-042

D4470-042

Parent Item Name: Aft Rib Assembly, RH

Start Date: 4/9/2015

Required Date: 4/29/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 13-01-17 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4470-2P		Purchased	No				Each	0.0000		1			
D4470-2P									**				
Aft Rib, RH													
M6061T6B1.000X04.00 0		Purchased	No				f	60.3250		2			
M6061T6B1 000X04 000									**				
6061-T6 Bar 1.00 x 4.00													

Location	Loc Qty	Loc Code
MAT003	60.325	
M126160	20.8	
M127797	2.925	
M128980	0.6	
M129167	36	

MS21069L08	Purchased	No				Each	745.0000						
MS21069L 08									**				
ANCHOR NUT													

Location	Loc Qty	Loc Code
ST301	745	
123522	745	

MS20426AD3-5	Purchased	No				Each	5,559.000						
MS20426AD3-5									**				
Rivet													

Location	Loc Qty	Loc Code
GA	4307	
4533	4307	
ST313	1252	
4444	1252	

1.41'
1.422'
J.C.-L
15/04/28
15/06/22
DAS
36
9-89
4
15/06/22
DAS
36
9-89
M131697
8X

DQA: _____ Date: _____



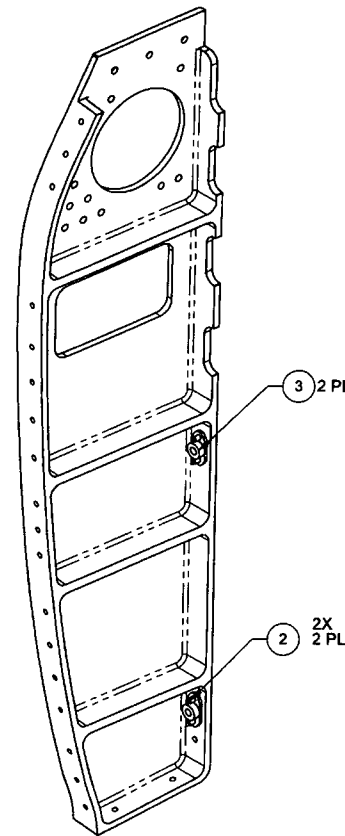
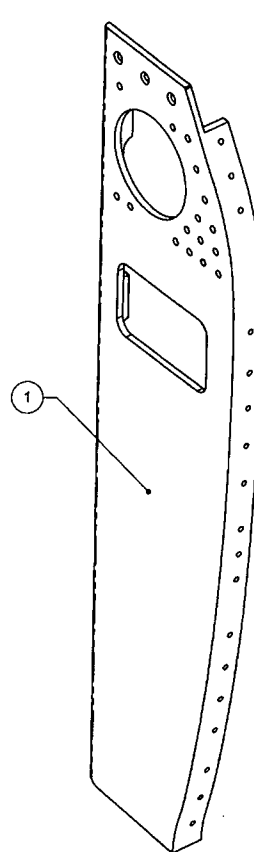
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

ITEM	QTY	P/N	DESCRIPTION
	X	D4470-042	AFT RIB ASSY (RH)
1	1	D4470-2	AFT RIB (RH)
2	4	MS20426AD3-5	RIVET, CSK
3	2	MS21069L08	NUTPLATE



mf.
131452

D4470-042 AFT RIB ASSY (RH)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.88 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	[Signature]	D4470	SHEET 4 OF 6
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	AFT RIB ASSY	NTS
DATE	12.12.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

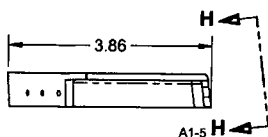


WORK ORDER NON-CONFORMANCE / UPDATE

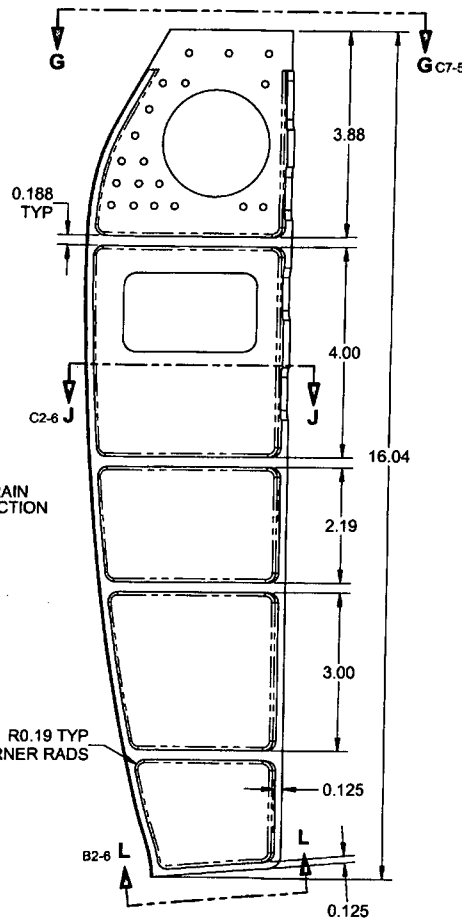
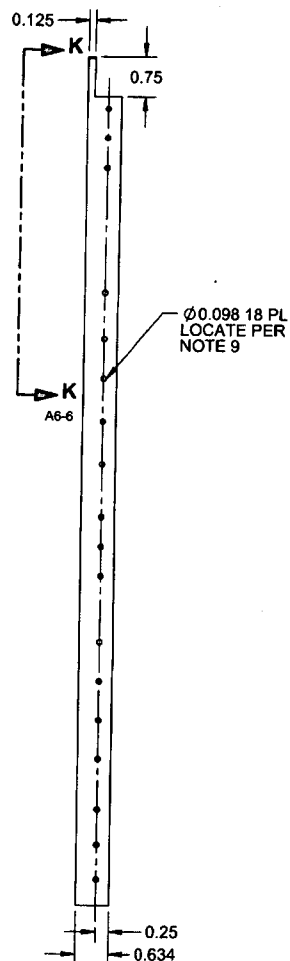
QA Closed: _____ Date: _____

Work Order update only ☐

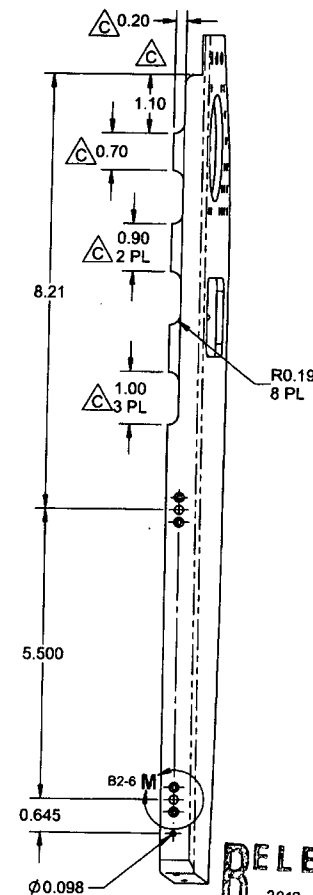
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



SECTION G-G D3-5



D4470-2 AFT RIB (RH)



VIEW H-H C7-5

- NOTES:**
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.88 lbs
 - 8) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART
(NOT NECESSARY TO FACE MATERIAL).
 - 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D4470-2-REV.C.STP"

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	AJS	D4470	SHEET 5 OF 6
APPROVED	AJS	TITLE	SCALE
DE APPR.	AJS	AFT RIB ASSY	NTS
DATE	12.12.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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RELEASED
2013-02-08

DQA: _____ Date: _____

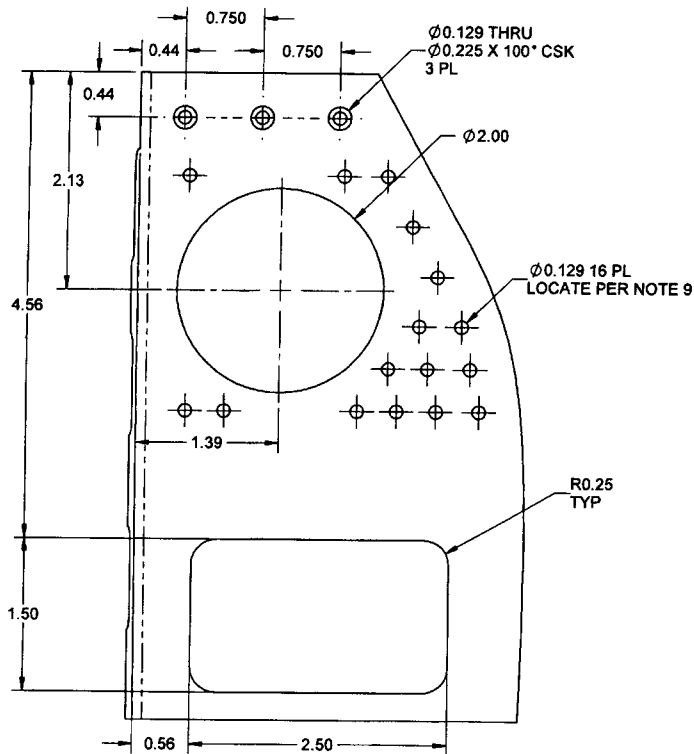


WORK ORDER NON-CONFORMANCE / UPDATE

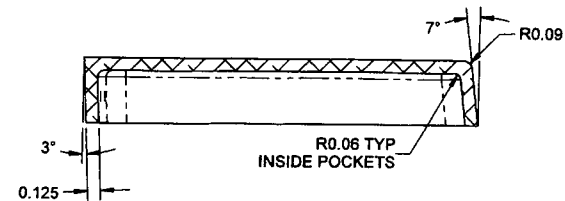
QA Closed: _____ Date: _____

Work Order update only ☐

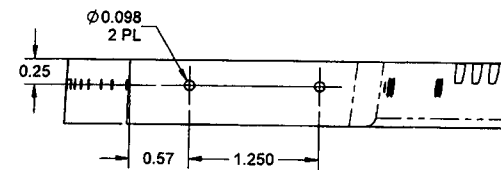
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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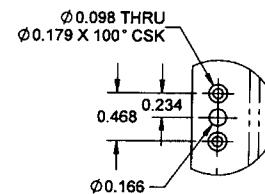
SECTION K-K C6-5
SCALE 2X



SECTION J-J C4-5
SCALE 2X



VIEW L-L B4-5
SCALE 2X



DETAIL M B2-5
NUTPLATE HOLE DETAIL 2 PL
SCALE 2X

RELEASED
2013-02-08

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4470	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT RIB ASSY	NTS
DATE	12.12.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28350**

Purchase Order Date 5/4/2015

PO Print Date 5/4/2015

Page Number 1 of 2

Order From :

VC-GLO001

ARCHER PRECISION INC.
2228 GLADWIN CRESENT
OTTAWA, ON K1B 4S6
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 899 2405

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
Line Comments		Promise Date					
Delivery Comments							
1	D4470-2P	Aft Rib, RH	5/15/2015		2.00	\$236.00	\$472.00
			Yes		Each		
			5/15/2015				
	AS PER DWG D4470 REV. C						
	B131452						
						Line Total:	\$472.00
2	71401-45	PROCUREMENT QUALITY CLAUSES	5/15/2015		1.00	\$0.00	\$0.00
			No				
			5/15/2015				
Procurement Quality Clauses							
A005 RIGHT OF ENTRY							
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)							
A016 PERSONNEL QUALIFICATION							
A026 CERTIFICATION OF MATERIAL CONFORMANCE							
A040 NOTIFICATION OF QUALITY ESCAPE							
A042 DART NOTIFICATION BY SUPPLIER							
A043 RETENTION OF QUALITY DOCUMENTS							

PO Instructions: Fedex Acc#151793240

Note:

5/4/2015



2228 Gladwin Crescent
Ottawa, Ontario
K1B 4S6

Phone # 613-899-2405

Packing Slip

Date	Invoice #
5/28/2015	1541

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
28350	5/28/2015	Delivery	Archer	

Qty	Item Code	Description
2	Sales	Rib (RH) - PN D4470-2P Rev.C HST (ON) on sales 8815-05-29



2228 Gladwin Cres.
Ottawa, Ont.
K1B 4S6

Telephone (613) 899-2405
Fax (613) 226-1719

Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

28 May 2014

Po Number	Part Number	Quantities
28350	D4494-042P (RH)	2

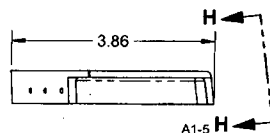
It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 28350 issued by Dart Aerospace Inc.

A handwritten signature in black ink, appearing to read "Greg Kumpula", is written over a horizontal line.

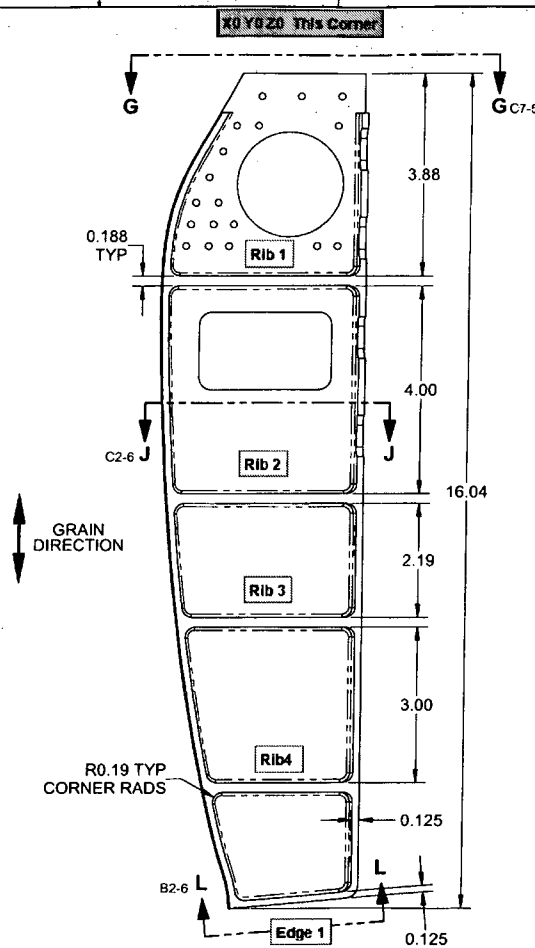
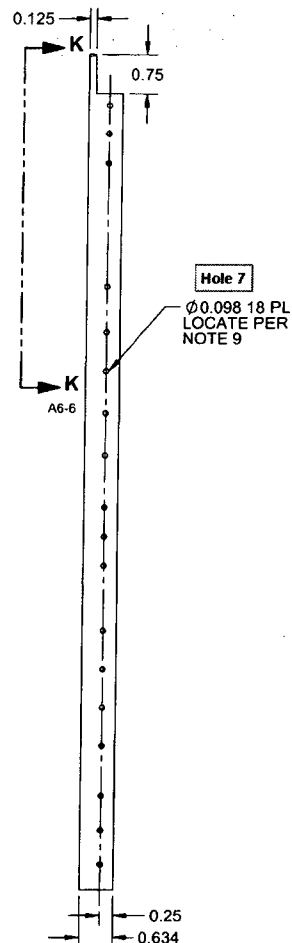
Greg Kumpula
Quality Inspector
Archer Precision Inc.
2228 Gladwin Cress.
Ottawa, Ontario
K1B 4S6

Important Note: The part made was RevC, no pdf was provided, only the CAD model

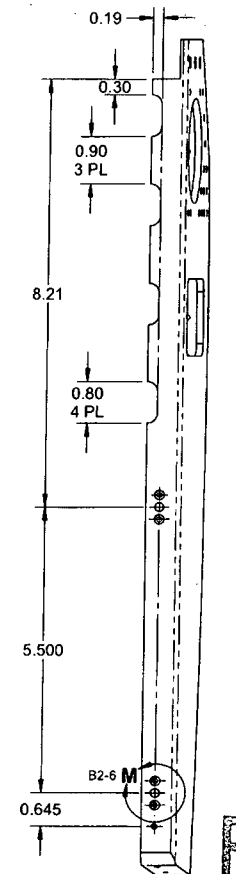
Note : Yellow numbered circles and text boxes match features on the inspection report.



SECTION G-G D3-5



D4470-2 AFT RIB (RH)



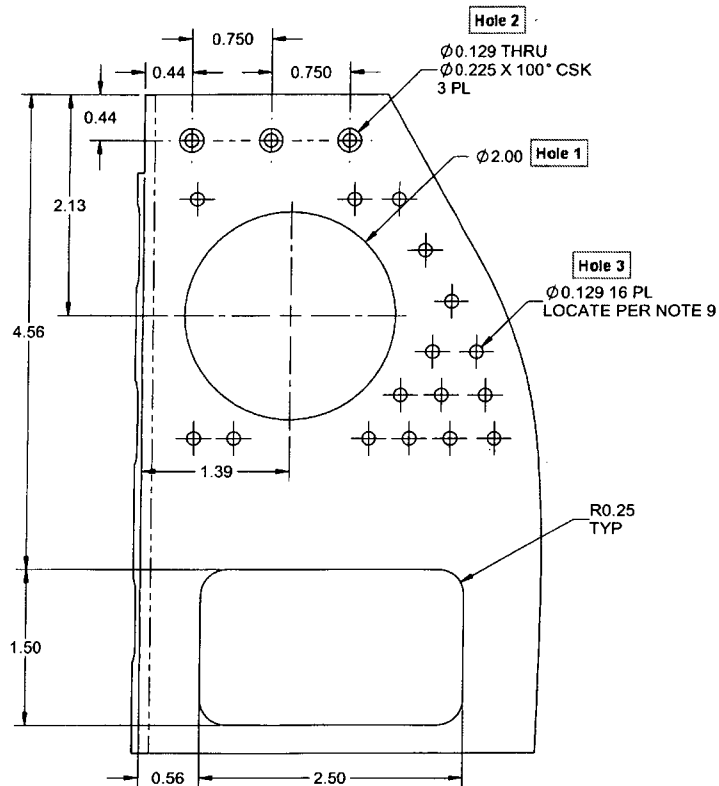
VIEW H-H C7-5

NOTES:

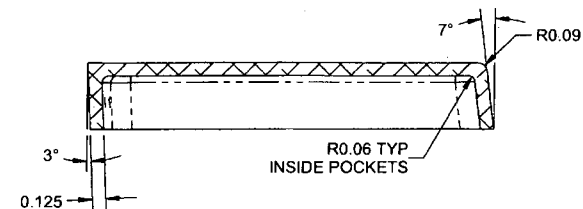
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.88 lbs
- 8) RAW MATERIAL SURFACE FINISH SUFFICIENT FOR THIS PART
(NOT NECESSARY TO FACE MATERIAL)
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE "D4470-2-REV.B.STP"

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.		D4470	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		AFT RIB ASSY	NTS
DATE	12.09.10	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

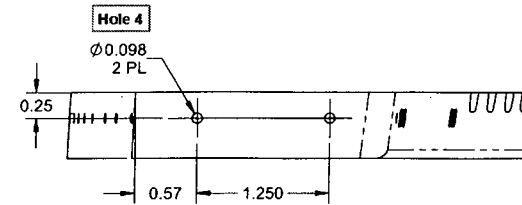
RELEASE
2012-09-18



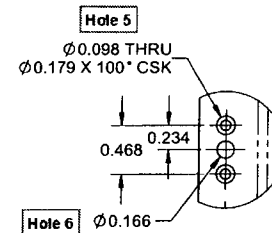
SECTION K-K C6-5
SCALE 2X



SECTION J-J C4-5
SCALE 2X

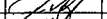


VIEW L-L B4-5
SCALE 2X



DETAIL M B2-5
NUTPLATE HOLE DETAIL 2 PL
SCALE 2X

RELEASED
2012-09-18
MP

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.		D4470	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		AFT RIB ASSY	NTS
DATE	12.09.10	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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INSPECTION REPORT

ZEISS

Date : 5/28/15

Customer : * u_cus *

Part No.: * u_prtnu *

Plan Name Dart D4470

Rev.:

Customer PO.: * u_Cuspo *

BSN :

Incr. Smpl No.: 1

Name	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
■ 1-dia-hole	D	2.00117	2.00000	0.00500	-0.00500	0.00117	-
■ 2 - width	CartDist	1.50123	1.49998	0.00500	-0.00500	0.00125	-
■ 3 - pocket depth	Z	-0.50958	-0.50900	0.00500	-0.00500	-0.00058	-
■ 4 - length	CartDist	2.50125	2.50000	0.00591	-0.00591	0.00125	-
■ 6 - Rib 1 Width	CartDist	0.19045	0.18800	0.00500	-0.00500	0.00245	--
■ 7 - Angle Bottom Side	A2	-6.97614	-7.00000	0.50000	-0.50000	0.02386	-
■ Angle Left End Outer	A	90.57108	90.60859	0.50000	-0.50000	-0.03751	-
■ Angle left Inner	A	90.00310	90.00000	0.50000	-0.50000	0.00310	-
■ Curve Form1	CurvForm	0.00106	0.00000	0.00500	-0.00500	0.00106	-
■ Curve Form2	CurvForm	0.00145	0.00000	0.00500	-0.00500	0.00145	-

CP#2

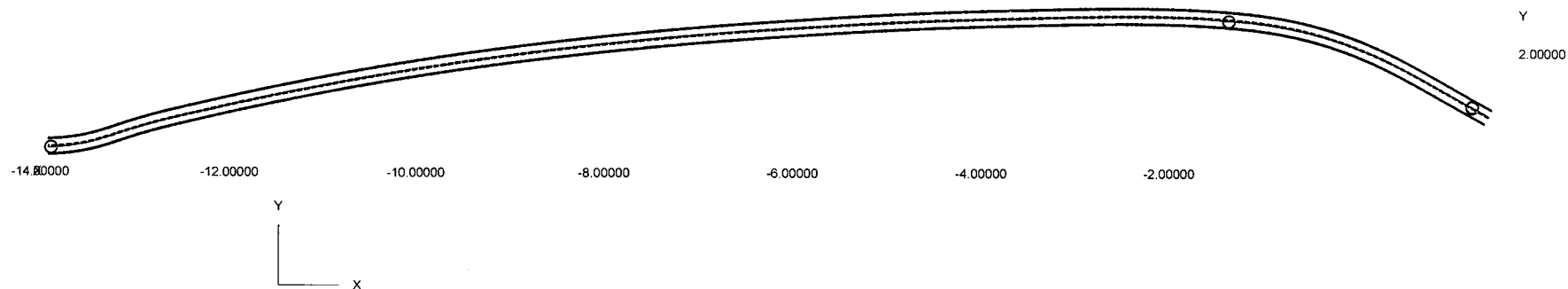
O/A THICKNESS @ .632 .634 $\pm .005$ - PASS

RAD IUS PROFILE - PASS.

OK.
ACHER-QL.

 Calypso 5.6.08		Carl Zeiss		Date Order	May 28, 2015
Part Number 1	CMM Type CONT_G2	Drawing No.		Department: Operator	Master
Meas. Plan Name		Dart D4470		Signature:	

1: Curve Form1



No	Identifier	Sigma [in]	Form [in]	Number of Points	Lower Tol. [in]	Upper Tol. [in]	MinInd	Min Dev. [in]	MaxInd	Max Dev. [in]	Best Fit	X [in]	Y [in]	Z [in]		X	Y	Z
1	Curve Form1	0.00017	0.00106	988	-0.00500	0.00500	191	-0.00053	14	0.00053	Translation	0.00093	-0.00059	0.00000	Rotation	0.00000	0.00000	0.00263
2	Curve Form2	0.00021	0.00145	1000	-0.00500	0.00500	998	-0.00089	14	0.00056	Translation	0.00060	-0.00033	0.00000	Rotation	0.00000	0.00000	0.00429